

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007943**Date Inspected:** 02-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** SUN BO**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

BAY#9

This QA Inspector randomly observed ZPMC welding personnel performing repair welding of fillet weld joints of DP-127-002-W1~W8 for Deck Panel DP-127-002(10AW). The personnel were observed welding in the 2F position utilizing a FCAW process. Welder is identified as 201250. The welding variables recorded by QC appeared to comply with the WPS- 345-FCAW-2G(2F)-REPAIR-1.

This QA Inspector randomly observed ZPMC welding personnel performing repair welding of fillet weld joints of DP-181-001-W1~W5 for Deck Panel DP-181-001(10AW). The personnel were observed welding in the 2F position utilizing a FCAW process. Welder is identified as 201250. The welding variables recorded by QC appeared to comply with the WPS- 345-FCAW-2G(2F)-REPAIR-1.

This QA Inspector randomly observed ZPMC welding personnel performing repair welding of fillet weld joints of DP-475-001-W1~W10 for Deck Panel DP-475-001(9CE). The personnel were observed Tack welding in the 2G position utilizing a FCAW process. Welder is identified as 059373. The welding variables recorded by QC appeared to comply with the WPS- B-T-2342-U5b(U-rib).

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Ultrasonic Testing(Phased Array)

The QA Inspector performed Phased Array Ultrasonic Testing (UT) on Orthotropic Box Girder deck plates to closed rib welds at the tack weld locations (Visual repaired area). The QA Inspector generated a field inspection UT report on this date designating areas of rejectable indications.

Panel identification number is

DP-424-001(10AE)

DP-153-001(9EW)

Green Tagging

This QA inspector performed final Visual Inspection for Deck Panels which were previously accepted by ZPMC Quality Control personnel and ABF QA personnel .

The member(s) are identified as

Deck Panel No.	Green Tagging No.
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DP-344-002(10BE)	007837
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DP-236-001(10BW)	007838
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DP-101-001(10BW)	007839
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DP-209-001(10BW)	007840
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DP-155-001(10BW)	007841
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Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
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Reviewed By:	Prue,Erik	QA Reviewer
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